

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-016947**Date Inspected:** 06-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower & OBG Components**Summary of Items Observed:**

On this date Caltrans Office of Structural Materials Quality Assurance Inspector, Sandeep Kumar (QA) was present during the times noted above for observations relative to the work being performed.

TOWER JETTY

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 25 located on East tower Lift-3, 99 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4214 – Tc – U4c.

Weld joint # 21 located on North tower Lift-3, 99 M cross bracing gusset plate to small doubler plate NSD1 – FASA3 – 1B/E. Welder is identified as 040582. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 3212– B – U2a – 2.

Weld joint # 28 located on South tower Lift-3, 99 M cross bracing gusset plate to small doubler plate SSD1 – FASA3 – 1B/E. Welder is identified as 057220. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 4212– Tc – U4c – 4.

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Weld joint # 24 located on West tower Lift-3, 99 M cross bracing gusset plate to small doubler plate WSD1 – FASA3 – 2B/E. Welder is identified as 040610. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 3212– B – U2a – 2.

Weld joint # 24 located on East tower Lift-3, 99 M cross bracing gusset plate to small doubler plate ESD1 – FASA3 – 2B/E. Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified Sun Zi Wang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 3212– B – U2a – 2.

BAY#10

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 09 located on North tower Lift-5 Grillage Assembly NSD1 – TL5 – 3B/F. Welder is identified as 066163. ZPMC Quality Control (QC) Inspector is identified as Yu Zhi Lai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – TC –U4c.
(See attached photo)

BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Weld joint # 03 located on West tower Lift-5 Grillage Assembly WSD1 – TL5 – 4B/F. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4c.

Weld joint # 19 located on East tower Lift-5 Grillage Assembly ESD1 – TL5 – 2B/F. Welder is identified as 054460. ZPMC Quality Control (QC) Inspector is identified as Xu Jie. The welding variables recorded by QC appeared to comply with the WPS – B – T – 3213 – Tc – U4c.

ORTHOTROPIC BOX GIRDER (OBG) AT BAY#11

This QA Inspector observed the following work in progress

Shielded Metal Arc Welding (SMAW):

Tack welding of a weld joint # 14 located on Bottom plate BP3093 – 001. Welder is identified as 052641. ZPMC Quality Control (QC) Inspector is identified as Yu Dong Ping. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 – FCM. (See attached photo)

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Michael Ng - 15921845703, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

Reviewed By: Clifford,William

QA Reviewer